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IS 8986 (1994): Percussive drilling - Drilling steels in bar form - Dimensions [MED 21: Diamond Core and Waterwell Drilling]

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आघात वेधन – सरिया रूप में वेधन इस्पात – आयाम

(पहला पुनरीक्षण)

Indian Standard

PERCUSSIVE DRILLING — DRILL STEELS
IN BAR FORM — DIMENSIONS

(*First Revision*)

UDC 669.14.018.256-422 : 622.232.5

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FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Diamond Core and Waterwell Drilling Sectional Committee had been approved by the Heavy Mechanical Engineering Division Council.

This standard was first published in 1978. In this revision hexagonal drill steel of nominal sizes 45 and 48 and round drill steel of normal size 50 have been deleted. The round drill steel of size 51 has been included.

In the preparation of this standard considerable assistance has been derived from the following standards published by the International Organization for Standardization (ISO):

ISO 722 : 1991 Rock drilling equipment — Hollow drill steels in bar form, hexagonal and round.

ISO 1721 : 1974 Rock drilling — Extension drill — Steel equipment for percussive long hole drilling — Reverse — Buttress — Threaded equipment 1 1/16 and 1 1/4 in (27 and 32 mm).

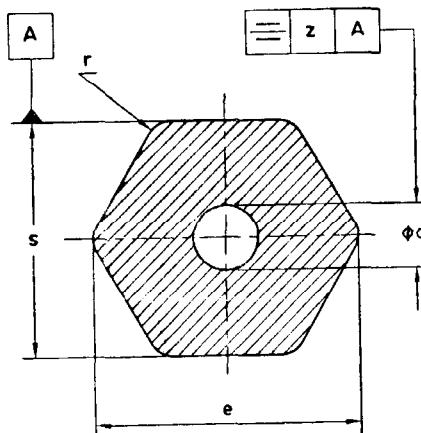
ISO 1722 : 1974 Rock drilling — Extension drill — Steel equipment for percussive long — Hole drilling — Reverse — Buttress — Threaded equipments 1 1/2 to 2 1/2 in (38 to 64 mm),

ISO 10207 : 1991 Rock drilling equipment — Rope threaded drill steel equipment for percussive drilling, normal sizes 22 mm to 38 mm.

ISO 10208 : 1991 Rock drilling equipment — Left hand rope threads.

*Indian Standard***PERCUSSIVE DRILLING — DRILL STEELS
IN BAR FORM — DIMENSIONS***(First Revision)***1 SCOPE**

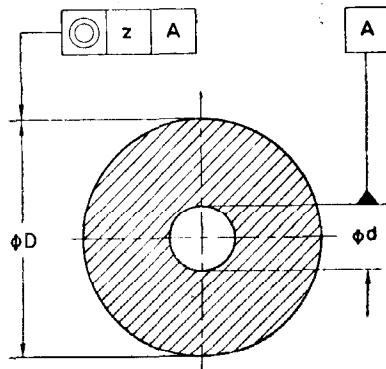
This standard specifies the dimensions for drill steels in bar form used for manufacture of integral drill steels, extension drill rods for long hole drilling.

2 DIMENSIONS**2.1 Hexagonal Integral Drill Steel and Extension Rods (See Table 1)****Table 1 Dimensions for Hexagonal Integral Drill Steel and Extension Rods**

Nominal Size	<i>s</i>	Tolerance on <i>s</i>	<i>e</i>	' <i>d</i> '	<i>r</i> + 1 0	Symmetry <i>z</i>	Sectional Area \approx mm ²	Mass \approx kg/m
19	19.2	+ 0.1 - 0.4	21.4	6 ± 0.5	1.5	0.75	285	2.2
22	22.4	+ 0.1 - 0.4	24.8	6.7 ± 0.6	2	0.75	390	3.1
*22A	22.4	+ 0.1 - 0.4	24.8	6.1 Min	2	0.75	390	3.1
25	25.6	0 - 0.6	28.5	7.6 ± 0.75	2	0.75	510	4
*25A	25.6	0 - 0.6	28.5	8.4 Min	2	0.75	495	3.9
*32	31.75	+ 0.53 - 0.33	35.2	8.8 Min	3.18	1.20	750	6.0
*38	38.10	+ 0.53 - 0.33	42.8	13.0 Min	3.18	1.20	1 060	8.3

2.2 Hollow Round Drill Steel in Bar Form for Extension Rods (See Table 2)

Table 2 Dimensions for Hollow Round Drill Steel in Bar Form for Extension Rods



All dimension in millimetres.

Nominal Size	D	Tolerance on D	d_{Min}	Coaxiality z	Sectional Area \approx mm ²	Mass \approx kg/m
32	32.4	$0 \text{ } - 0.7$	8.8	0.8	740	5.7
38	39.5	$0 \text{ } - 1.0$	13	1.0	1090	8.5
45	45.5	$0 \text{ } - 1.4$	14.5	1.5	1470	11.5
51	52.6	$0 \text{ } - 1.6$	16	1.5	1920	15.0

3 DESIGNATION

A hexagonal drill steel (letters H and R shall be used to designate section/hexagonal and round drill steel respectively) of 25A nominal size shall be designated as:

Drill Steel 25AH IS 8986

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